

# Work Order ID 83964

Monday, April 30, 2012 11:19:24 AM

**\*83964\***

Ship mail *pm* Page 1

Item ID: D3914-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Long Basket Lid Assembly (350)  
 Start Date: 5/1/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 5/11/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: mf Date: 12-04-30 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	B								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: 118366 0.00  
**\*100\***  
 Large Fab  
 Large Fab  
 Memo 0.00  
 1- assemble ribs, weld as per dwg D3914 using DT9607A  
 2- weld hinge (3) and Mounting brackets as per dwg D3914  
 \*\*\*Visual inspect before welding mesh\*\*\*  
 3- tack weld mesh on basket as per dwg D3914  
 \*\*\*Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

*1x* *Ø* *12.05.14*  
*Pl 12.05.14*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00  
**\*110\***  
 QC  
 Quality Control  
 Memo 0.00

*1* *0* *BE*  
*12.05.14*

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				<u>①</u>			<u>M/L 12-05-14</u>
130 <b>*130*</b> Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo *** mask sides of hinge prior to powdercoat*** Start Time: <u>1-30</u> Oven Temperature: <u>3200 F</u> Finish Time: <u>2-20</u>	0.00  0.00				<u>IX</u>	<u>φ</u>		<u>M/L 12/05/14</u>
140 <b>*140*</b> HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch _____  Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***	0.00  0.00				<u>1</u>	<u>φ</u>		<u>BL 12-5-14</u>

M117338

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Page 3

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Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150	QC3- Inspect Part Finish	0.00							
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**\*150\***

QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: **DA272-02****\*160\***

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

**83955.****1 0 BK 12-5-14****1x 0 Al 12/05/15  
MC5 12/05/15****MF  
12-05-15**

# Picklist Print

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Page 1

Work Order ID: 83964

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/1/2012

Required Date: 5/11/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
10.08.18 verified by:EC

IPP Rev:B as per dwg revB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	88.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		5							
				82506		5							
				WA005		83							
				70766		2							
				81253		1							
				82017		40							
				82897		40							
D3914-1 Rib		Manufactured	No			100	Each	9.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		6							
				82926		4							
				WA006		3							
				81449		4							
				82131		1							
D3914-7 Rib		Manufactured	No			100	Each	6.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		-5							
				81209		1							
				WA006		11							
				82927		5							

2 *lpl* 2 *SAD* 12-05-07

2 *lpl* 2 *SAD* 12-05-07

2 *lpl* 2 *SAD* 12-05-07

2

# Picklist Print

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Page 2

Work Order ID: 83964

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/1/2012

Required Date: 5/11/2012

Start Qty: 1.00

Required Qty: 1.00

D4016-3 Manufactured No  
Hinge Half, Lid

100 Each 14.0000

3 PL/SAD 12-05-07

Location

Loc Qty

Loc Code

WA

14

82523

6

82968

8

3

D4018-5 Manufactured No  
Rib

100 Each 7.0000

9 PL/SAD 12-05-07

Location

Loc Qty

Loc Code

WA005

7

80776

1

81179

6

83868

9

D4020-5 Manufactured No  
Mesh (350 Basket Long, Lid)

100 Each 0.0000

1 882513 PL 12-05-07

D4021-3 Manufactured No  
Data Plate

100 Each 14.0000

1 PL/SAD 12-05-07

Location

Loc Qty

Loc Code

WA

10

80897

9

82507

1

WA005

4

81451

4

D4035-041 Manufactured No  
Lid Rib Assembly, Fwd (350 Basket)

100 Each 2.0000

1 PL/SAD 12-05-07

Location

Loc Qty

Loc Code

WA006

2

81192

2

83231

1

# Picklist Print

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Work Order ID: 83964

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/1/2012

Required Date: 5/11/2012

Start Qty: 1.00

Required Qty: 1.00

D4035-043

Manufactured No

100 Each 2.0000

Lid Rib Assembly, Aft (350 Basket)

1 Pl / 3 Aft 12-05-07

Location

Loc Qty

Loc Code

WA

1

81452

1

WA006

1

81202

1

D2728-3

Manufactured No

140 Each

8323 2  
0.0000

Dart Logo label

115060

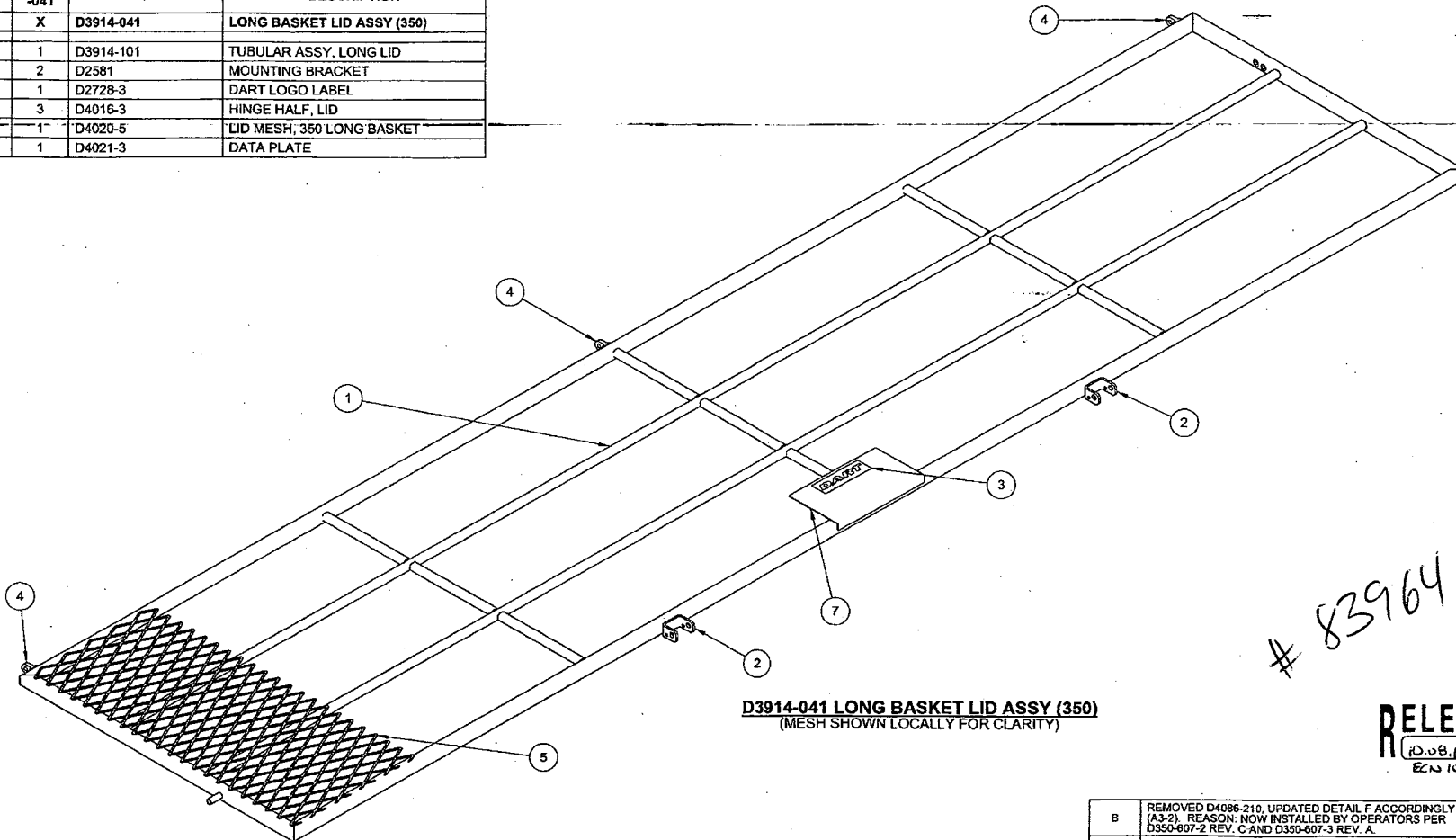
1 1 BR 12-5-14

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Shop Packet Print

Page 3

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

# 83964

**RELEASED**  
10.08.17  
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	ALS		
APPROVED	ALS		
DE APPR.	ALS		
DATE	10.08.05		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3914  
TITLE LONG BASKET LID ASSY (350)  
REV. B  
SHEET 1 OF 4  
SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

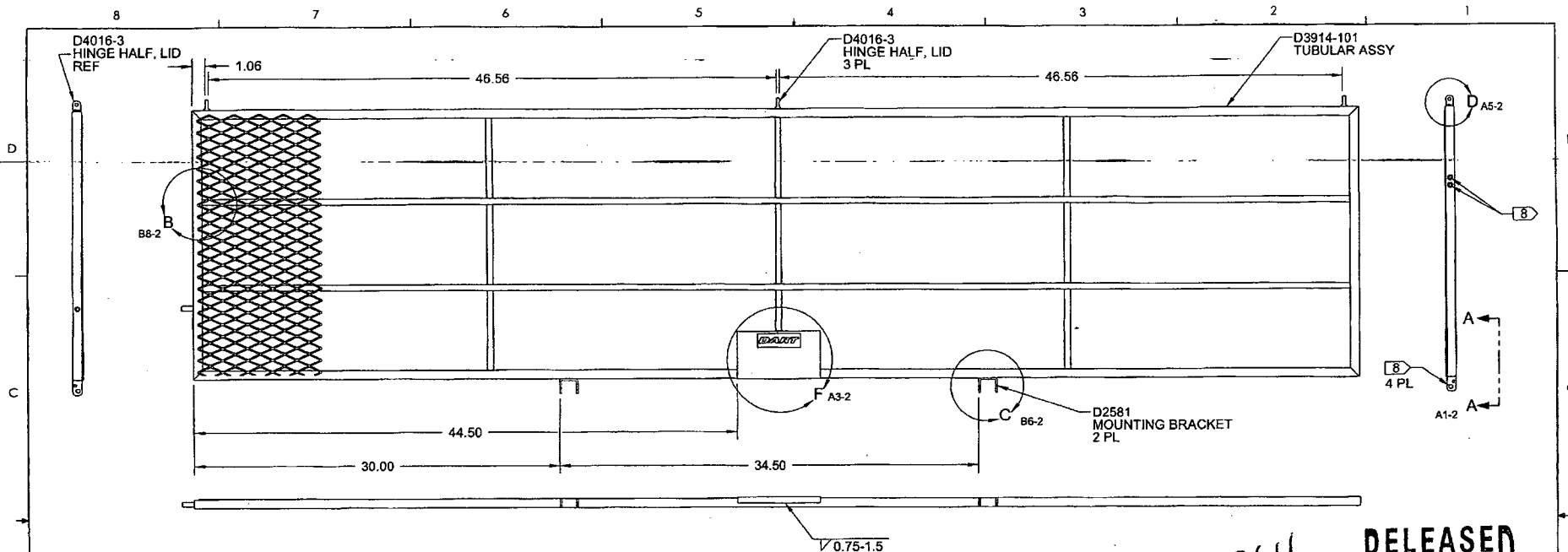
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

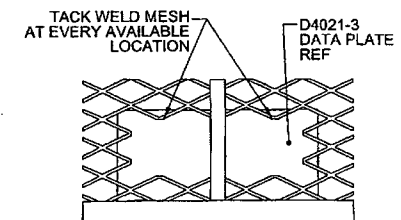
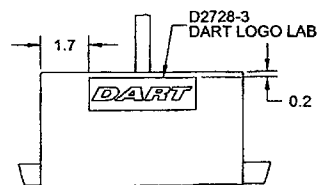
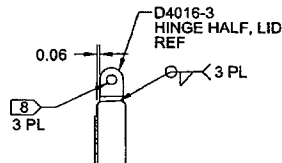
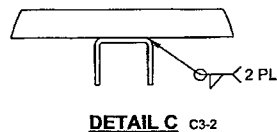
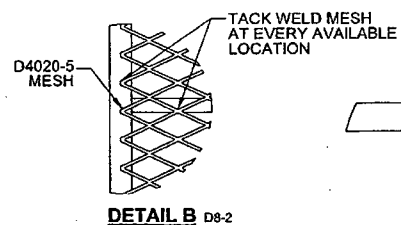
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	WJ	D3914	SHEET 2 OF 4
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	LONG BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
10.08.05

#83964

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

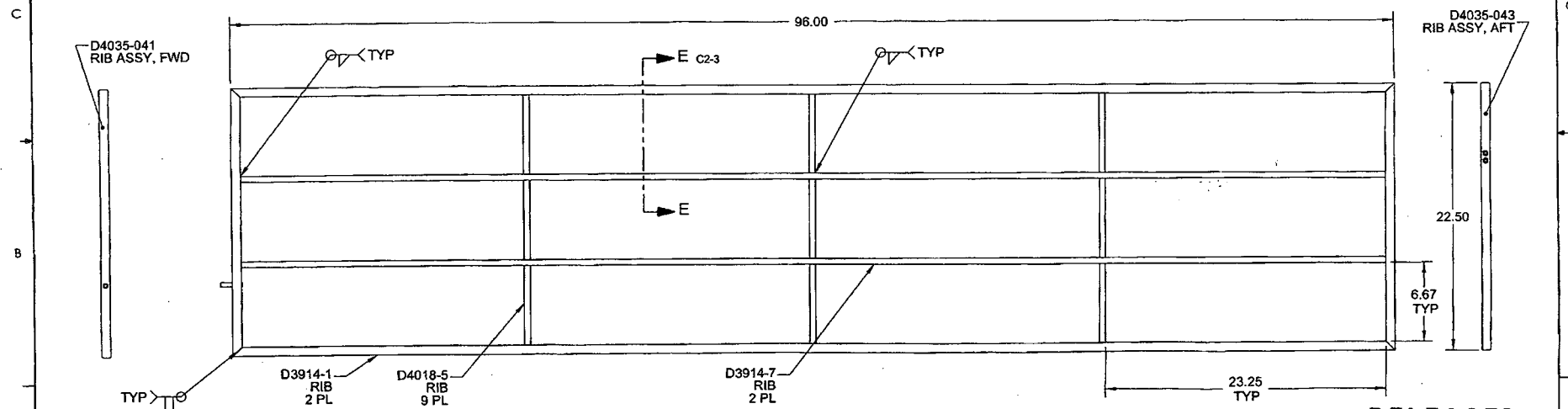
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E CS-3



(B) D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS	DRAWING NO. D3914	REV. B
CHECKED	AS	SHEET 3 OF 4	
MFG. APPR.	AS	TITLE LONG BASKET LID ASSY (350)	SCALE NTS
APPROVED	AS	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DE APPR.	AS	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

RELEASED  
10-28-12

#83964

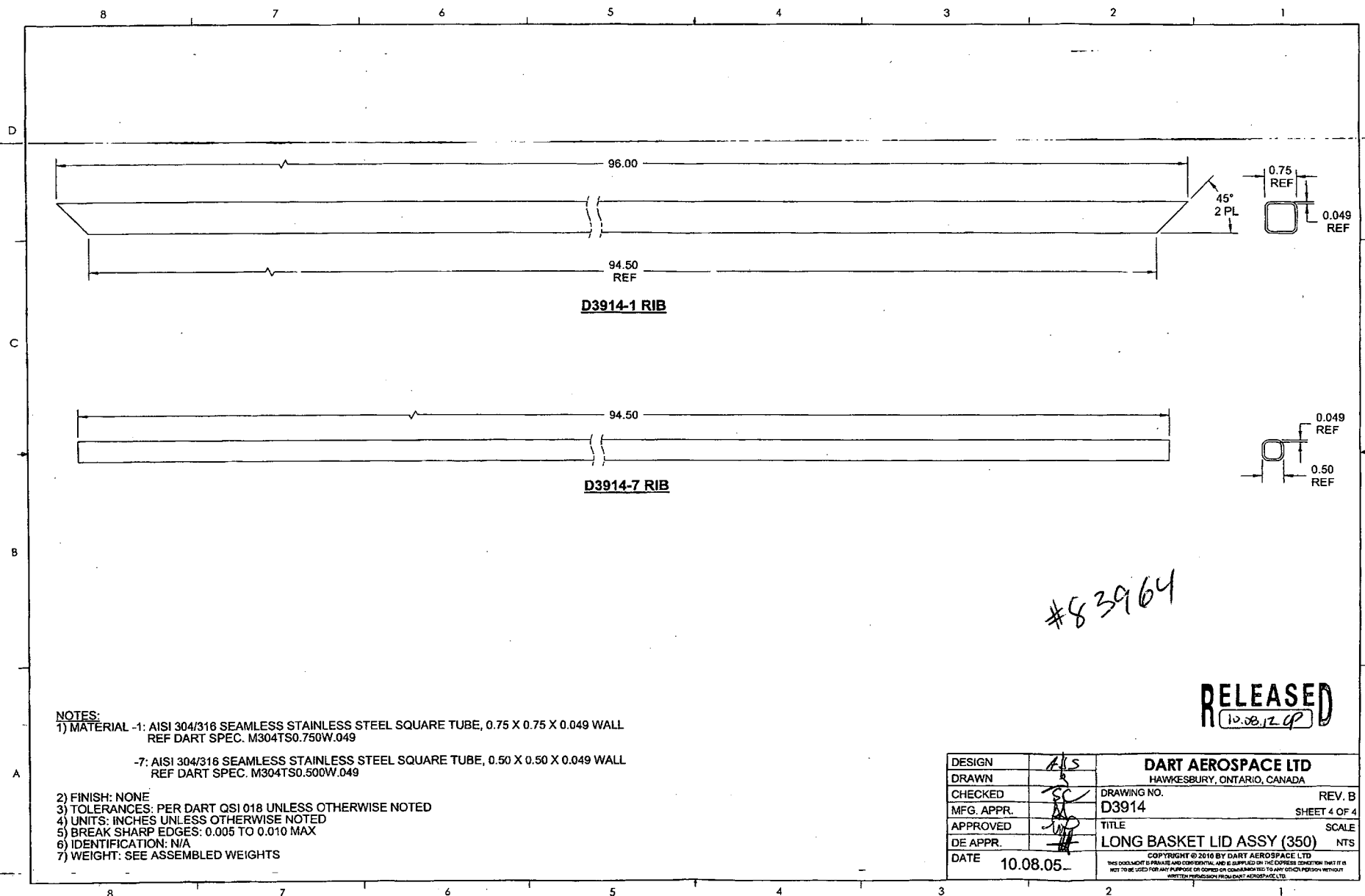
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries